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**D350-591-121**  
**Job Sheet 186516**



Part No: D350-591-121

Job Qty: 2 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 12/14/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP  
KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

6019

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                 |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|--------------------------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                          |
| 90    | Start up Operation | 2 Ea  |            | 12/14/18 | 0.00      | 0.00    | Start Up Large Fab-4  |           | MA                       |
| 110   | Large Fab          | 2 pcs |            | 12/14/18 | 0.00      | 1.36    | Large Fab 8           |           | MA                       |
| 120   | CNC Bend Skidtubes | 2 pcs |            | 12/14/18 | 0.38      | 0.59    | CNC Bend Skidtube     |           | MA DAS 38                |
| 122   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC5                   |           | MA 9-80                  |
| 140   | Large Fab          | 2 pcs |            | 12/14/18 | 0.00      | 1.36    | Large Fab 2           |           | MA                       |
| 150   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC9                   |           | MA                       |
| 160   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC5                   |           | MA                       |
| 170   | HandFinish         | 2 pcs |            | 12/14/18 | 0.00      | 0.37    | HandFinish1           |           | MA BEB 18-12-3           |
| 180   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC7-2                 |           | MA                       |
| 190   | Large Fab          | 2 pcs |            | 12/14/18 | 0.00      | 1.36    | Large Fab 2           |           | MA                       |
| 220   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC10                  |           | MA                       |
| 230   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC5                   |           | MA                       |
| 240   | HandFinish         | 2 pcs |            | 12/14/18 | 0.00      | 0.37    | HandFinish1           |           | MA                       |
| 250   | Powdercoat         | 2 pcs |            | 12/14/18 | 0.00      | 0.32    | Powdercoat1           |           | MA BK 18-12-3            |
| 260   | HandFinish         | 2 pcs |            | 12/14/18 | 0.00      | 0.37    | HandFinish3           |           | MA BEB 18-12-3           |
| 270   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC3                   |           | MA DAS DEC 04 2018 68    |
| 280   | Packaging          | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | Packaging1-3          |           | MA DAS DEC 04 2018 9-89  |
| 290   | QC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | QC4                   |           | MA                       |
| 300   | Packaging          | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | Packaging3-1          |           | MA DAS DEC 04 2018 Fg039 |
| 305   | DC                 | 2 pcs |            | 12/14/18 | 0.00      | 0.00    | DC                    |           | MA                       |
| 310   | QC21-FG            | 2 Ea  |            | 12/14/18 | 0.00      | 0.00    | QC21                  |           | MA DAS DEC 04 2018       |

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using DT8230.

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

140 - 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 &amp; Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod 3-Do not Grind Flush

190 - 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 &amp; Dwg D2351 A/RAluminum Rod 3-Grind end plate flush.

250 - START TIME: 0.25 OVEN TEMPERATURE: 300° FINISH TIME: 305.

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

305 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

M138963 wing walk.

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88  
1946

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1946



## Job BOM

| Part / Item   | Component Name            | Quantity      | Operation             | Container |
|---------------|---------------------------|---------------|-----------------------|-----------|
| D2244-116     | Step Extrusion            | 1 Ea (.5 ea)  | 90-Start up Operation | B 164533  |
| D2850-1       | End Bracket               | 2 Ea (1 ea)   | 140-Large Fab         | 5133680   |
| D2582         | Hi-Skid Step Leg Assembly | 2 Ea (1 ea)   | 190-Large Fab         | 5121733   |
| D2673-34      | End Plate                 | 2 Ea (1 ea)   | 190-Large Fab         | 5078838   |
| MS20600-AD4W3 | Cherry Rivet              | 32 Ea (16 ea) | 190-Large Fab         | 5110003   |
| AN3-37A       | Bolt                      | 4 Ea (2 ea)   | 280-Packaging         | 5057513   |
| AN4-13A       | Bolt                      | 2 Ea (1 ea)   | 280-Packaging         | 5115326   |
| AN4-16A       | Bolt                      | 4 Ea (2 ea)   | 280-Packaging         | 5122084   |
| D2230-1       | Mounting Lug              | 2 Ea (1 ea)   | 280-Packaging         | 5118557   |
| D2230-3       | Mounting Lug              | 2 Ea (1 ea)   | 280-Packaging         | 5130628   |
| D2732-030     | Rubber Cushion - 3"       | 4 Ea (2 ea)   | 280-Packaging         | 5121242   |
| MS21042L3     | Nut                       | 4 Ea (2 ea)   | 280-Packaging         | 5094592   |
| MS21042L4     | Nut                       | 6 Ea (3 ea)   | 280-Packaging         | 5097136   |
| NAS1149D0363J | Washer                    | 8 Ea (4 ea)   | 280-Packaging         | 5097182   |
| NAS1149D0463J | Washer                    | 12 Ea (6 ea)  | 280-Packaging         | 5092780   |

## Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D2244-116      | 1        | 86        | 0         |
| 140-Large Fab         | D2850-1        | 2        | 10        | 0         |
| 190-Large Fab         | D2582          | 2        | 5         | 0         |
|                       | D2673-34       | 2        | 23        | 0         |
|                       | MS20600-AD4W3  | 32       | 305       | 0         |
| 280-Packaging         | AN3-37A        | 4        | 76        | 0         |
|                       | AN4-13A        | 2        | 950       | 0         |
|                       | AN4-16A        | 4        | 468       | 0         |
|                       | D2230-1        | 2        | 17        | 0         |
|                       | D2230-3        | 2        | 53        | 0         |
|                       | D2732-030      | 4        | 192       | 0         |
|                       | MS21042L3      | 4        | 1,880     | 0         |
|                       | MS21042L4      | 6        | 1,888     | 0         |
|                       | NAS1149D0363J  | 8        | 2,068     | 0         |
|                       | NAS1149D0463J  | 12       | 2,662     | 0         |

## Part Specifications

Specifications could not be found.

Plex 11/16/18 11:28 AM dart.white.jesse



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Container No: S129068



Part: D350-591-121

Job No: 186516

Serial No/Batch: S129068

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11 <sup>1998</sup> FAA: STC SH967NE 04/12/21, BRAZIL 1



## 5.0 PARTS LIST

| Qty<br>-117A | Qty<br>-119 | Qty<br>-133 | Part Number   | Description                                     |
|--------------|-------------|-------------|---------------|-------------------------------------------------|
| X            |             |             | D350-591-117A | <i>Heli-Access-Step</i> ™, Pre-Flight Step      |
|              | X           |             | D350-591-119  | <i>Heli-Access-Step</i> ™, Long Step – Low Skid |
|              |             | X           | D350-591-133  | <i>Heli-Access-Step</i> ™, Aft Maintenance Step |
|              | 1           |             | D2355         | STEP ASSEMBLY (LOW-LONG)                        |
|              |             | 1           | D2946-041     | STEP ASSEMBLY (MAINTENANCE)                     |
| 2            | 2           |             | D2171         | CLAMP                                           |
| 2            | 2           |             | D2182B035     | CUSHION                                         |
|              |             | 4           | D2230-1       | MOUNTING LUG                                    |
|              |             | 4           | D2230-3       | MOUNTING LUG                                    |
| 4            | 4           |             | D2274         | RADIUS BLOCK                                    |
| 1            |             |             | D2362-041     | SUPPORT BRACKET                                 |
|              | 1           |             | D2362-3       | SUPPORT BRACKET                                 |
|              |             | 1           | D2945         | MOUNTING PLATE                                  |
| 1            | 1           |             | D3595-200-300 | CUSHION                                         |
|              |             | 8           | D2732-030     | CUSHION                                         |
|              | 2           |             | AN3-37A       | BOLT                                            |
|              |             | 2           | AN4-7A        | BOLT                                            |
|              |             | 4           | AN4-11A       | BOLT                                            |
|              |             | 8           | AN4-16A       | BOLT                                            |
|              | 4           |             | AN4-21A       | BOLT                                            |
| 4            | 1           |             | AN4-22A       | BOLT                                            |
|              | 4           |             | NAS1149D0363J | WASHER (AN960JD10)                              |
| 4            | 6           | 14          | NAS1149D0463J | WASHER (AN960JD416)                             |
|              | 2           |             | MS21042L3     | NUT                                             |
| 4            | 5           | 14          | MS21042L4     | NUT                                             |

REFERENCE ONLY

| Qty<br>-121 | Qty<br>-122 | Qty<br>-123 | Qty<br>-124 | Part Number   | Description                                           |
|-------------|-------------|-------------|-------------|---------------|-------------------------------------------------------|
| X           |             |             |             | D350-591-121  | <i>Heli-Access-Step</i> ™, Short Step – High Skid, LH |
|             | X           |             |             | D350-591-122  | <i>Heli-Access-Step</i> ™, Short Step – High Skid, RH |
|             |             | X           |             | D350-591-123  | <i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH  |
|             |             |             | X           | D350-591-124  | <i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH  |
| 1           |             |             |             | D2351-041     | STEP ASSEMBLY (HIGH-SHORT, LH)                        |
|             | 1           |             |             | D2351-042     | STEP ASSEMBLY (HIGH-SHORT, RH)                        |
|             |             | 1           |             | D2356-041     | STEP ASSEMBLY (LOW-SHORT, LH)                         |
|             |             |             | 1           | D2356-042     | STEP ASSEMBLY (LOW-SHORT, RH)                         |
| 1           | 1           | 1           | 1           | D2230-1       | MOUNTING LUG                                          |
| 1           | 1           | 1           | 1           | D2230-3       | MOUNTING LUG                                          |
| 2           | 2           | 2           | 2           | D2732-030     | CUSHION                                               |
| 2           | 2           | 2           | 2           | AN3-37A       | BOLT                                                  |
| 1           | 1           | 1           | 1           | AN4-13A       | BOLT                                                  |
| 2           | 2           | 2           | 2           | AN4-16A       | BOLT                                                  |
| 4           | 4           | 4           | 4           | NAS1149D0363J | WASHER (AN960JD10)                                    |
| 6           | 6           | 6           | 6           | NAS1149D0463J | WASHER (AN960JD416)                                   |
| 2           | 2           | 2           | 2           | MS21042L3     | NUT                                                   |
| 3           | 3           | 3           | 3           | MS21042L4     | NUT                                                   |

REFERENCE ONLY

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Revision: I  
Date: 18.05.25

7.10.10.10.10

7.10.10.10.10



## Change Record

PAGE 1 OF 1

Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

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